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Examiner: G. Marlo

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**IMPROVED PROCESS FOR PRODUCING
POLYBUTADIENE GOLF BALL CORES**

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FIELD OF THE INVENTION

This invention relates generally to golf balls, and specifically to golf balls containing polybutadiene cores. In this regard, the present invention concerns an improved process for producing polybutadiene rubber compositions, and the resulting molded cores and finished golf balls produced utilizing such a process.

BACKGROUND OF THE INVENTION

The present invention is directed to improved processing methods for polybutadiene rubber compositions suitable for molded golf ball core constructions. More particularly, the present invention is directed to improved processing methods for polybutadiene rubber compositions having a high Mooney viscosity and/or a high molecular weight and a low dispersity. The use of such polybutadiene rubber increases the resiliency of a golf ball without increasing the hardness of the ball.

Two of the principal properties involved in the performance of golf balls are resilience and hardness. Resilience is determined by the coefficient of restitution (referred to as "C.O.R."), also expressed as the constant "e", which is the ratio of the relative velocity of two elastic spheres after direct impact to that before impact. More generally, the constant "e" is the ratio of the outgoing velocity to the incoming velocity of a rebounding ball. The coefficient of restitution (i.e. "e") can vary from zero to one, with one being equivalent to an elastic collision and zero being equivalent to an inelastic collision.

Hardness is determined as the deformation (i.e. compression) of the ball under various load conditions applied across the ball's diameter. The lower the compression value, the harder the material.

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Resilience (C.O.R.), along with additional factors such as clubhead speed, angle of trajectory, and ball configuration (i.e. dimple pattern), generally determine the distance a ball will travel when hit. Clubhead speed and the angle of trajectory are factors not easily
5 controllable, particularly by golf ball manufacturers. Thus, the factors of concern to manufacturers are the coefficient of restitution (C.O.R.) and the surface configuration of the ball.

The coefficient of restitution of a golf ball is generally measured by propelling a ball at a given speed against a hard surface and
10 electronically measuring the ball's incoming and outgoing velocity. The coefficient of restitution must be carefully controlled in all commercial golf balls in order for the ball to be within the specifications regulated by the United States Golfers Association ("U.S.G.A.").

The U.S.G.A. standards dictate that a "regulation" ball can
15 not have an initial velocity (i.e. the speed off the club) exceeding 255 feet per second (250 feet per second with a 2% tolerance). Since the coefficient of restitution of a ball is related to the ball's initial velocity (i.e. as the C.O.R. of a ball is increased, the ball's initial velocity will also increase), it is highly desirable to produce a ball having a sufficiently high
20 coefficient of restitution to closely approach the U.S.G.A. limit on initial velocity, while having an ample degree of hardness (i.e. impact resistance) to produce enhanced durability.

The coefficient of restitution (C.O.R.) for a solid core golf ball is a function of the composition of the molded core and of the cover.
25 Copending U.S. Patent Application Serial No. 09/226,340, filed January 6, 1999, and titled "Golf Ball Cores Formed from Ultra-high Mooney Viscosity Butadiene Rubber", is assigned to the same assignee as the present invention and is hereby incorporated by reference. This copending application discloses an improved polybutadiene composition that exhibits
30 a high Mooney viscosity and/or a high molecular weight and low dispersity

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that, when utilized to formulate golf ball cores, produces golf balls exhibiting enhanced C.O.R. without increasing hardness.

However, while high molecular weight polybutadiene rubbers exhibit improved C.O.R., they are very difficult to mill. That is, they tend to "bag", crumble, and break into pieces during the milling process. Bagging occurs when the core stock becomes loose and "bags" or droops down away from a roller associated with a conventional two-roll mill (described further below) thus preventing the core stock from being cut by knife blades associated with the mill.

Conventional processing aids can be added to the butadiene rubber (BR) core stock to improve the core stock's milling characteristics. However, the processing aids disadvantageously lower the core stock's coefficient of restitution. Accordingly, it is an object of the present invention to provide improved processing methods for polybutadiene rubber compositions that exhibit a high Mooney viscosity and/or a high molecular weight and a low dispersity.

These and other objects and features of the invention will be apparent from the following summary and description of the invention and from the claims.

SUMMARY OF THE INVENTION

The present invention achieves all of the foregoing objectives and provides, in a first aspect, a processing system for forming golf ball preforms. The processing system includes an internal mixer that compounds a batch of golf ball core stock, the internal mixer having a mixer outlet; a sheeter that forms sheets of golf ball core stock, the sheeter having a sheeter inlet proximate the mixer outlet and having a sheeter outlet, and a preform shaper for forming golf ball core preforms from the sheets of golf ball core stock.

In another aspect, the present invention provides a method of forming golf ball core preforms. The method includes compounding a

FOOTNOTES

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batch of golf ball core stock in a mixer; sheeting the batch of compounded golf ball core stock with a sheeter, the sheeter including an extruder portion having at least one screw; and shaping golf ball preforms from the sheeted batch of golf ball core stock.

5 Further scope of the applicability of the invention will become apparent from the detailed description provided below.

BRIEF DESCRIPTION OF THE DRAWINGS

The invention may take form in various components and arrangements of components, and in various steps and arrangements of
10 steps. The drawings are only for purposes of illustrating a preferred embodiment(s) and are not to be construed as limiting the invention.

Figure 1 shows a golf ball (single core) according to the present invention;

15 Figure 2 illustrates another golf ball (dual layer core) according to the present invention;

Figure 3 diagrammatically illustrates a known method of processing butadiene rubber compositions;

20 Figure 4 diagrammatically illustrates a method of processing butadiene rubber compositions in accordance with a first embodiment of the present invention;

Figure 5 is a top view of a twin-screw sheeter shown in Figure 4;

Figure 6 is a side view of a known two-roll warm-up mill;

Figure 7 is a side view of a known hydraulic extruder;

25 Figure 8 is an end view of the hydraulic extruder taken along the line 8-8 of Figure 7;

Figure 9 diagrammatically illustrates a method of processing butadiene rubber compositions in accordance with a second embodiment of the present invention;

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Figure 10 is a top view of a twin-screw sheeter shown in Figure 9; and

Figure 11 is a front view of a die head portion of the twin-screw sheeter taken along the line 11-11 of Figure 10.

5 DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

The present invention concerns the production of solid polybutadiene cores for golf ball construction. The solid cores may be of single (Fig. 1) or multilayer construction (Fig. 2).

Referring now to the drawings, and in particular to Figure 1,
10 a golf ball 1 according to the present invention is shown. The ball has a core 2, which is solid and is formed from a suitable polybutadiene core composition. A cover 3 surrounds the core 2 to form an unfinished two-piece golf ball. A thin primer coat 4a is applied to the outer surface of cover 3. A thin top coat 4b surrounds the primer coat 4a to form a
15 finished golf ball. The thicknesses of primer coat 4a and top coat 4b are exaggerated for illustrative purposes.

Figure 2 shows a further multi-layered embodiment of the invention. The golf ball, which is designated as 5, has an inner core 6, which is solid and is formed from a suitable polybutadiene core
20 composition. An outer core 7 surrounds the inner core 6. One or more ionomeric outer cover layers 8 surround the outer core 7. A thin primer coat 9a is applied to the outer surface of the cover layer 8. A thin top coat 9b surrounds the primer coat 9a. The thicknesses of primer coat 9a and top coat 9b are exaggerated for illustrative purposes.

Figure 3 illustrates a known processing system A for
25 compounding a batch of polybutadiene (BR) rubber composition suitable for the molded golf ball core constructions shown in Figures 1 and 2. A compounding conveyor line 10 delivers pre-weighed bales of polybutadiene rubber 12 to an internal mixer 14. A bulk storage system
30 16 includes a number of hoppers 18 for storing bulk powders such as zinc

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It is expected that the core stock will form a smooth band around the front roller, and will adhere to the front roller without bagging, ripping, forming holes or breaks in the stock. As mentioned, bagging occurs when the core stock becomes loose and "bags" or droops down
5 away from the front roller so that the knife blades do not cut the core stock. The cut sheet 33 is manually placed on a conveyor 34 and is then fed into a batch-off cool down unit 36 where the sheet 33 is festooned between moving hangers 38 to be cooled by forced air. As indicated above, it is important that the sheet of core stock be smooth and
10 continuous because any rips or breaks in the core stock will cause the sheet to fall off the hangers 38.

As mentioned, copending U.S. Patent Application Serial No. 09/226,340^{now US 6,127,920} discloses an improved polybutadiene composition having a high Mooney viscosity and/or a high molecular weight and low dispersity
15 that, when utilized to formulate golf ball cores, produces golf balls that exhibit enhanced C.O.R. without increasing hardness. However, the disclosed high Mooney polybutadiene rubber is very difficult to sheet off the conventional two-roll mill 26. That is, the high Mooney core stock bags, rips, and forms holes and cannot be easily stripped off the front
20 roller 28 to form the continuous sheet 33. Instead, the high Mooney core stock must be manually stripped off the front roller 28 in small pieces and chunks, and dumped onto wooden pallets to cool.

It should be appreciated that it is not only the high Mooney BR rubber that is difficult to process. Newer high performance, softer
25 compression core stocks are "polymer rich" and do not contain high levels of ZDA or excess fillers or extenders to smooth out the core stock. It is possible to improve the processing of polybutadiene rubber by adding natural rubber, polyisoprene, process oils, plasticizers, liquid co-agents, etc. However, these additives disadvantageously lower the performance
30 of the resulting core stock (i.e. the additives reduce the coefficient of restitution of the core stock).

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Referring now to Figures 4 and 5, a first embodiment of a processing system B for compounding an improved polybutadiene composition having a high Mooney viscosity and/or a high molecular weight and low dispersity is shown. To facilitate describing the processing system B, the same reference numerals are used to indicate components previously described with reference to the processing system 10 of Figure 3.

Bales of high Mooney BR rubber 52 and bulk powders are intimately mixed together within the mixer 14 until a uniform composition is obtained. When mixing is completed, the core stock 54 is dropped through a bottom door of the mixer 14 and into a retaining hopper 55 of a sheeter 56. The sheeter includes an extruder portion 58 and a two-roll calender portion 60.

In the embodiment being described the extruder portion 58 includes a screw housing 62 with two conical or tapered extruder screws 64, 66, and a drive housing 68. The twin screws 64, 66 are water-cooled and the screw housing 62 is jacketed to control the temperature of the core stock.

A drive motor 70, through a reducing drive 72 and coupling 74, drives a first drive shaft 76 that is rotationally fixed to a screw shaft 78 of the extruder screw 64. The first drive shaft 76 is coupled to a second drive shaft 80 by two sets of counterrotating gears 82, 84 such as inclined tooth bevel gears or intermeshing herringbone tooth bevel gears. The second drive shaft 80 is rotationally fixed to a screw shaft 86 of the extruder screw 66. Both drive shafts 76, 80 are journaled in bearings 88. Further, the drive shafts 76, 80 are coupled to the respective screw shafts 78, 86 by couplings 90, 92. It should be appreciated that the screw shafts 78, 86 can be journaled in thrust bearings 94, 96.

It should also be appreciated that the extruder portion can include a single extruder screw if desired. Further, other drive arrangements are contemplated such as individual direct drives for each

of the extruder screws 64, 66. A sheeter suitable for use in the present invention is a Twin-Screw Sheeter™ TSS-series sheeter manufactured by Farrel Corporation of Ansonia, Connecticut. Suitable single and twin screw sheeters are also available from Pomini, Inc., Rubber & Plastic Division,
5 of Brecksville, Ohio.

In operation, the core stock 54 is dropped into the retaining hopper 55 that is positioned around a throat entrance to the screw housing 62. The counter rotating screws 64, 66 force the core stock toward and into the two-roll calender portion 60. The calender portion 60 includes a
10 fixed-position bottom roller 100 directly driven by a gear reducer and motor assembly (not shown), or by a hydraulic motor (not shown).

A movable top roller 102 extends parallel with the bottom roller and is driven from the bottom roller by connecting gears (not shown). The rollers 100, 102 cooperate to smooth the core stock fed by the screws
15 64, 66 into a sheet 104 approximately 36" wide. The sheet is then transferred to the batch-off cool down unit 36 in the same manner described above.

It should be appreciated that the sheeter 56 does not require any operators because the core stock 54 is directly formed into the sheet
20 104 via the screws 64, 66 and two-roll calender portion 60. It should also be appreciated that, with the sheeter, the core stock does not band around either of the rollers 100, 102, but is passed straight through a nip point between the rollers 100, 102 to form the sheet 104 having a desired gauge (i.e. thickness).

25 The cooled core stock is then tested to determine various physical and rheological properties of the particular batch such as compression, C.O.R., etc. The batch is then processed into individual slugs or preforms that are ultimately compression molded into golf ball cores. More particularly, as shown in Figure 6, one or more batches of
30 core stock are fed into a conventional two-roll warm-up mill 110. It should

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be appreciated that different batches of core stocks can be combined together in the mill 110 to produce slugs having certain properties.

5 The two-roll warm-up mill 110 includes horizontally-disposed front and back rollers 112, 114 that rotate in opposite directions as indicated by the illustrated arrows. The back roller 114 extends parallel with the front roller 112 to define a nip point 116. In the embodiment being described, both rollers are about 60" long (wide) and heat the core stock to about 145°F. As with the two-roll mill 26, the heated core stock bands around the front roller 112. An operator manually strips a portion
10 of the banded core stock off the front roller 112 to form a "pig". A "pig" is a rolled-up strip of heated core stock that has a predetermined diameter, such as approximately 10"-12". It is contemplated that a "pig rolling" device could be used to automatically roll the heated core stock into "pigs" of the required diameter.

15 The "pigs" have a temperature of about 145°F after coming off the warm up mill 110. It is known that this temperature produces a smooth preform or slug. Cold "pigs" produce very rough slugs, and more pressure is required to force the stock through a preform die (discussed below). It is contemplated that cold "pigs" can be pre-warmed to
20 approximately 145°F in a hot air oven prior to forming the slugs. Suitable hot air ovens are available from Barwell Inc. of Tallmadge, Ohio 44278.

As shown in Figures 7 and 8, one or more "pigs" of heated core stock 120 are taken off the warm-up mill 110 and fed into a hydraulic
25 extruder 122 such as a known Barwell Preformer device. The Barwell Preformer includes a cylinder portion 124 having a die head portion 126 at one end and a hydraulic ram portion 128 at the other end. In operation, the one or more pigs 120 are loaded into the cylinder 124 and the die head 126 is closed and locked. A vacuum is applied to the inside of the
30 cylinder to remove any air that could cause voids or air pockets in the slugs. The hydraulic ram 128 at the far end of the cylinder forces the core

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stock 120 through a Teflon oval die 130 associated with the die head 126. As a solid oval rod of core stock exits the die 130, a cutting device 132 cuts the rod into preforms or slugs.

It is contemplated that the cutting device 132 can have one
5 or more cutting blades or other means for cutting the core stock into the preforms or slugs of predetermined size and/or weight. The weight or size of the cut preforms are controlled through a volume control that synchronizes the cutting device 132 with the advance of the hydraulic ram 128. The cut slugs or preforms are then dusted with an anti-sticking agent
10 such as zinc stearate to keep them from sticking together. The slugs are then compression molded to form golf ball cores in a conventional manner.

It should be appreciated that the heated sheet of core stock 104 (Fig. 4) that is discharged from the sheeter 56 could be directly rolled into "pigs" (either manually or automatically) rather than being conveyed
15 to the batch off cool down unit 36 as described above. However, in this alternate embodiment, it is not feasible to combine different batches of core stock (to produce certain core properties) prior to forming the "pigs".

Referring now to Figures 9 and 10, a second embodiment of a processing system C for compounding an improved polybutadiene
20 composition having a high Mooney viscosity and/or a high molecular weight and low dispersity is shown. Again, to facilitate describing the processing system C, the same reference numerals are used to indicate components previously described with reference to the processing systems of Figures 3-8.

25 Bales of high Mooney BR rubber 52 and bulk powders are intimately mixed together within the mixer 14 until a uniform composition is obtained. When mixing is completed, the core stock 54 is dropped through a bottom door of the mixer 14 and into a retaining hopper 150 of a sheeter 152. The sheeter includes the extruder portion 58 and a die
30 head portion 154.

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pages 565-566, also herein incorporated by reference. Generally, polybutadiene rubbers have Mooney viscosities, measured at 212°F, of from about 25 to about 65. Instruments for measuring Mooney viscosities are commercially available such as a Monsanto Mooney Viscometer, Model MV 2000. Another commercially available device is a Mooney viscometer made by Shimadzu Seisakusho Ltd.

As will be understood by those skilled in the art, polymers may be characterized according to various definitions of molecular weight. The "number average molecular weight," M_n , is defined as:

$$M_n = \frac{\sum W_i}{\sum W_i / M_i}$$

where W_i is the molecular weight of a fraction or sample of the polymer and M_i is the total number of fractions or samples.

"Weight average molecular weight," M_w , is defined as:

$$M_w = \frac{\sum W_i M_i}{\sum W_i}$$

where W_i and M_i have the same meanings as noted above.

The "Z-average molecular weight," M_z , is defined as:

$$M_z = \frac{\sum W_i M_i^2}{\sum W_i M_i}$$

where W_i and M_i also have the same meanings as noted above.

" M_{peak} " is the molecular weight of the most common fraction or sample, i.e. having the greatest population.

Considering these various measures of molecular weight, provides an indication of the distribution or rather the "spread" of molecular weights of the polymer under review.

A common indicator of the degree of molecular weight distribution of a polymer is its "polydispersity," P :

$$P = \frac{M_w}{M_n}$$

Polydispersity, or "dispersity" as sometimes referred to herein, also provides an indication of the extent to which the polymer chains share the same degree of polymerization. If the polydispersity is 1.0, then all polymer chains have the same degree of polymerization. Since weight
5 average molecular weight is always equal to or greater than the number average molecular weight, polydispersity, by definition, is equal to or greater than 1.0:

$$P \geq 1.0$$

The particular polybutadiene for use in the preferred
10 embodiment compositions of the present invention (i) exhibits a Mooney viscosity of from about 65 to about 85, and preferably from about 70 to about 83; ii) has a number average molecular weight M_n of from about 90,000 to about 130,000; and preferably from about 100,000 to about 120,000; iii) has a weight average molecular weight M_w of from about
15 250,000 to about 350,000; and preferably from about 290,000 to about 310,000; iv) has a Z-average molecular weight M_z of about 600,000 to about 750,000; and preferably from about 660,000 to about 700,000; and, v) has a peak molecular weight M_{peak} of about 150,000 to about 200,000; and preferably from about 170,000 to about 180,000.

20 The polydispersity of the particular polybutadiene for use in the preferred embodiment compositions typically ranges from about 1.9 to about 3.9; and preferably from about 2.4 to about 3.1. Most preferably, the polydispersity is about 2.7.

The particular polybutadiene for use in the preferred
25 embodiment compositions preferably contains a majority fraction of polymer chains containing a cis-1, 4 bond, more preferably, having a cis-1,

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4 polybutadiene content of about 90%, and most preferably, having a cis-
1,4 polybutadiene content of at least about 95%. Although not wishing to
be bound to any particular theory, the present inventor has also discovered
that a preferred polybutadiene, as described herein, is obtained by utilizing
5 a cobalt or cobalt-based catalyst. However, polybutadienes exhibiting the
foregoing characteristics, which are obtained by using a lanthanum rare
earth catalyst, nickel catalyst, or mixtures thereof, are also encompassed
by the present invention. It is also envisioned that other catalysts could
be utilized to produce the particular preferred polybutadienes described
10 herein. Examples of such other catalysts include, but are not limited to
aluminum, boron, lithium, neodymium, titanium, and combinations thereof.

The polybutadiene utilized in the present invention is a solid
at room temperature. Consequently, the polybutadiene is referenced as
a "solid" polybutadiene, as opposed to a "liquid" which generally means
15 that the rubber is flowable at room temperature.

A commercially available polybutadiene corresponding to the
noted preferred ultra-high viscosity polybutadiene, and which is suitable for
use in the preferred embodiment compositions in accordance with the
present invention is available under the designation Cariflex BCP 820,
20 from Shell Chimie of France. The properties and characteristics of this
preferred polybutadiene are set forth below in Table 1.

TABLE 1

Properties of Shell Chimie BCP 820 (Also known as BR-1202J)

	<u>Property</u>	<u>Value</u>
25	Mooney Viscosity (approximate)	73-83
	Volatiles Content	0.5% maximum
	Ash Content	0.1% maximum
	Cis 1,4-polybutadiene Content	95.0% minimum
	Stabilizer Content	0.2 to 0.3%
30	Polydispersity	2.7

	<u>Molecular Weight Data:</u>	<u>Trial 1</u>	<u>Trial 2</u>
	M _n	110,000	111,000
	M _w	300,000	304,000
	M _z	680,000	
5	M _{peak}	175,000	

The compositions of the present invention may also utilize other polybutadiene resins in addition to the noted particular polybutadiene exhibiting an ultra-high Mooney viscosity, such as the BCP 820 resin. For example, Cariflex BR-1220 polybutadiene available from Shell Chemical
 10 (see Table 2 below); and Taktene 220 polybutadiene available from Bayer Corp. of Orange, Texas (see Tables 3A and 3B below) may be utilized as other polybutadienes in combination with the particular ultra-high Mooney viscosity polybutadiene component described herein. Generally, these other polybutadienes have Mooney viscosities in the range of about 25 to
 15 65. It is also contemplated that a similar polybutadiene resin, BCP 819, commercially available from Shell Chimie, may be used in conjunction with BCP 820.

TABLE 2
Properties of Cariflex BR-1220 Polybutadiene

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Physical Properties:

Polybutadiene Rubber

CIS 1,4 Content - 97%-99% Min.

Stabilizer Type - Non Staining

Total Ash - 0.5 % Max.

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Specific Gravity - 0.90-0.92

Color - Transparent, clear, Lt. Amber

Moisture - 0.3% max. ASTM 1416.76 Hot Mill Method

Polymer Mooney Viscosity - (35 - 45 Cariflex) (ML1+4 @ 212°F)

90% Cure - 10.0 - 13.0

30

Polydispersity 2.75 - 3.0

Molecular Weight Data:

Trial 1

Trial 2

M_n

80,000

73,000

M_w

220,000

220,000

M_z

550,000

35

M_{peak}

110,000

TABLE 3A

Properties of Taktene 220 Polybutadiene

Physical Properties:

5	Polybutadiene Rubber
	CIS 1, 4 Content (%) - 98% Typical
	Stabilizer Type - Non Staining 1.0 - 1.3%
	Total Ash - 0.25 Max.
	Raw Polymer Mooney Visc. -35-45 40 Typical
	(ML1+4'@212 Deg. F./212°F)
10	Specific Gravity - 0.91
	Color - Transparent - almost colorless (15 APHA Max.)
	Moisture % - 0.30% Max. ASTM 1416-76 Hot Mill Method

TABLE 3B

Properties of Taktene 220 Polybutadiene

15	<u>Product Description</u>	A low Mooney viscosity, non-staining, solution polymerized, high cis-1,4-polybutadiene rubber.		
20	<u>Raw Polymer Properties</u>	<u>Property</u>	<u>Range</u>	<u>Test Method</u>
		Mooney viscosity 1+4(212°F)	40 ± 5	ASTM D 1646
		Volatile matter (wt %)	0.3 max.	ASTM D 1416
		Total Ash (wt %)	0.25 max.	ASTM D 1416
25	<u>Cure⁽¹⁾⁽²⁾ Characteristics</u>	Minimum torque		
		M _L (dN.m)	9.7 ± 2.2	ASTM D 2084
		(lbf.in)	8.6 ± 1.9	ASTM D 2084
		Maximum torque		
		M _H (dN.m)	35.7 ± 4.8	ASTM D 2084
		(lbf.in)	31.6 ± 4.2	ASTM D 2084
30		t ₂ 1 (min)	4 ± 1.1	ASTM D 2084
		t'50 (min)	9.6 ± 2.5	ASTM D 2084
		t'90 (min)	12.9 ± 3.1	ASTM D 2084
35	<u>Other Product Features</u>	<u>Property</u>	<u>Typical Value</u>	
		Specific gravity	0.91	
		Stabilizer type	Non-staining	

- (1) Monsanto Rheometer at 160°C, 1.7 Hz (100 cpm), 1 degree arc, micro-die
- (2) Cure characteristics determined on ASTM D 3189 MIM mixed compound:

5	TAKTENE 220	100 (parts by mass)
	Zinc oxide	3
	Stearic acid	2
	IRB #6 black (N330)	60
	Naphthenic oil	15
10	TBBS	0.9
	Sulfur	1.5

* This specification refers to product manufactured by Bayer Corp., Orange, Texas, U.S.A.

The preferred embodiment core compositions of the present invention generally comprise about 100 parts by weight of elastomeric or rubber components, i.e. the noted ultra-high Mooney viscosity polybutadiene, and from about 60 to about 80, or more, parts by weight of non-rubber or non-elastomeric components. Preferably, the core compositions comprise about 100 parts of rubber components and from about 60 to about 80, or more, parts by weight of non-rubber components. It will be understood that depending upon the types and respective function of components added to the non-rubber portion of the preferred embodiment core compositions, that the non-rubber portion may constitute a significant proportion of the rubber component. The rubber components include the previously described ultra-high Mooney viscosity polybutadiene. The non-rubber components are as follows.

Preferably, the crosslinking agent of the core composition is an unsaturated carboxylic acid component which is the reaction product of a carboxylic acid or acids and an oxide or carbonate of a metal such as zinc, magnesium, barium, calcium, lithium, sodium, potassium, cadmium, lead, tin, and the like. Preferably, the oxides of polyvalent metals such as zinc, magnesium and cadmium are used, and most preferably, the oxide is zinc oxide.

Exemplary of the unsaturated carboxylic acids which find utility in the preferred core compositions are acrylic acid, methacrylic acid, itaconic acid, crotonic acid, sorbic acid, and the like, and mixtures thereof. Preferably, the acid component is either acrylic or methacrylic acid.

5 Usually, from about 15 to about 50, and preferably from about 20 to about 35 parts by weight of the carboxylic acid salt, such as zinc diacrylate (ZDA), is included per 100 parts of the rubber components in the core composition. The unsaturated carboxylic acids and metal salts thereof are generally soluble in the elastomeric base, or are readily dispersible.

10 The free radical initiator included in the core composition is any known polymerization initiator (a co-crosslinking agent) which decomposes during the cure cycle. The term "free radical initiator" as used herein refers to a chemical which, when added to a mixture of the elastomeric blend and a metal salt of an unsaturated, carboxylic acid,
15 promotes crosslinking of the elastomers by the metal salt of the unsaturated carboxylic acid. The amount of the selected initiator present is dictated only by the requirements of catalytic activity as a polymerization initiator. Suitable initiators include peroxides, persulfates, azo compounds and hydrazides. Peroxides which are readily commercially available are
20 conveniently used in the present invention, generally in amounts of from about 0.1 to about 10.0 and preferably in amounts of from about 0.3 to about 3.0 parts by weight per each 100 parts of elastomer.

Exemplary of suitable peroxides for the purposes of the present invention are dicumyl peroxide, n-butyl 4,4' - bix (butylperoxy) valerate, 1,1-bis (t-butylperoxy) -3,3,5-trimethyl cyclohexane, di-t-butyl
25 peroxide and 2,5-di-(t-butylperoxy)-2,5 dimethyl hexane and the like, as well as mixtures thereof. It will be understood that the total amount of initiators used will vary depending on the specific end product desired and the particular initiators employed.

30 Examples of such commercial available peroxides are Luperc 230 or 231 XL, a peroxyketal manufactured and sold by Atochem,

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Lucidol Division, Buffalo, New York, and Trigonox 17/40 or 29/40, a peroxyketal manufactured and sold by Akzo Chemie America, Chicago, Illinois. The one hour half life of Luperco 231 XL and Trigonox 29/40 is about 112°C, and the one hour half life of Luperco 230 XL and Trigonox 17/40 is about 129°C. Luperco 230 XL and Trigonox 17/40 are n-butyl-4, 4-bis(t-butylperoxy) valerate and Luperco 231 XL and Trigonox 29/40 are 1, 1-di(t-butylperoxy) 3,3, 5-trimethyl cyclohexane.

The core compositions of the present invention may additionally contain any other suitable and compatible modifying ingredients including, but not limited to, metal oxides, fatty acids, and diisocyanates. For example, Papi 94, a polymeric diisocyanate, commonly available from Dow Chemical Co., Midland, Michigan, is an optional component in the rubber compositions. It can range from about 0 to 5 parts by weight per 100 parts by weight rubber (phr) component, and acts as a moisture scavenger.

Various activators may also be included in the compositions of the present invention. For example, zinc oxide and/or magnesium oxide are activators for the polybutadiene. The activator can range from about 2 to about 10 parts by weight per 100 parts by weight of the rubbers (phr) component.

The preferred fillers are relatively inexpensive and heavy and serve to lower the cost of the ball and to increase the weight of the ball to closely approach the U.S.G.A. weight limit of 1.620 ounces. Exemplary fillers include mineral fillers such as limestone, zinc oxide, silica, mica, barytes, calcium carbonate, or clays. Limestone is ground calcium/magnesium carbonate and is used because it is an inexpensive, heavy filler. Other heavy weight fillers include metal particles, such as powdered tungsten.

As indicated, ground flash filler may be incorporated and is preferably 20 mesh ground up center stock from the excess flash from

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compression molding. It lowers the cost and may increase the hardness of the ball.

Fatty acids or metallic salts of fatty acids, or metal soaps, may also be included in the compositions, functioning to improve moldability and processing. Generally, free fatty acids having from about 10 to about 40 carbon atoms, and preferably having from about 15 to about 20 carbon atoms, are used. Exemplary of suitable fatty acids are stearic acid, palmitic, oleic and linoleic acids, as well as mixtures thereof. Exemplary of suitable metallic salts of fatty acids include zinc stearate. When included in the core compositions, the fatty acid component is present in amounts of from about 1 to about 25, preferably in amounts from about 20 to about 15 parts by weight based on 100 parts rubber (elastomer).

It is preferred that the core compositions include stearic acid as the fatty acid adjunct in an amount of from about 2 to about 5 parts by weight per 100 parts of rubber.

Diisocyanates may also be optionally included in the core compositions when utilized, the diisocyanates are included in amounts of from about 0.2 to about 5.0 parts by weight based on 100 parts rubber. Exemplary of suitable diisocyanates is 4,4'-diphenylmethane diisocyanate and other polyfunctional isocyanates known to the art.

Furthermore, the dialkyl tin difatty acids set forth in U.S. Patent No. 4,844,471, the dispersing agents disclosed in U.S. Patent No. 4,838,556, and the dithiocarbonates set forth in U.S. Patent No. 4,852,884 may also be incorporated into the polybutadiene compositions of the present invention. The specific types and amounts of such additives are set forth in the above-identified patents, which are incorporated herein by reference.

As indicated above, additional suitable and compatible modifying agents such as fatty acids, and secondary additives such as Pecan shell flour, ground flash (i.e. grindings from previously manufactured

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5 The core compositions of the invention are generally comprised of 100 parts by weight of a base elastomer (or rubber) selected from polybutadiene and mixtures of polybutadiene with other elastomers, 15 to 25 parts by weight of at least one metallic salt of an unsaturated carboxylic acid, and 1 to 10 parts by weight of a free radical initiator.

In producing golf ball cores utilizing the disclosed compositions, the ingredients may be processed using the processing systems B and C. It should be appreciated that the sequence of adding the ingredients into the mixer 14 is not critical. However, a preferred blending sequence is as follows.

The elastomer, polypropylene powder resin (if desired), fillers, zinc salt, metal oxide, fatty acid, and the metallic dithiocarbamate (if desired), surfactant (if desired), and tin difatty acid (if desired), are blended for about 7 minutes in the internal mixer 14. As a result of shear during mixing, the temperature rises to about 200°F. The initiator and diisocyanate are then added and the mixing continued until the temperature reaches about 220°F whereupon the batch is discharged onto the sheet 56, 152 and sheeted out.

The sheets are eventually formed into slugs or preforms vis-a-vis the die head 154 or the hydraulic preformer 122. The slugs are then subjected to compression molding at about 320°F for about 14 minutes. After molding, the molded cores are cooled, the cooling effected at room temperature for about 4 hours or in cold water for about one hour. The molded cores are subjected to a centerless grinding operation whereby a thin layer of the molded core is removed to produce a round core having a diameter of 1.540 to 1.545 inches. Alternatively, the cores are used in the as-molded state with no grinding needed to achieve roundness.

It should be appreciated that the mixing is desirably conducted in such a manner that the composition does not reach incipient polymerization temperatures during the blending of the various components.

Usually the curable component of the composition will be cured by heating the composition at elevated temperatures on the order of from about 275°F to about 350°F, preferably and usually from about 290°F to about 325°F, with molding of the composition effected simultaneously with the curing thereof. The composition can be formed into a core structure by any one of a variety of molding techniques, e.g. injection, compression, or transfer molding. When the composition is cured by heating, the time required for heating will normally be short, generally from about 10 to about 20 minutes, depending upon the particular curing agent used. Those of ordinary skill in the art relating to free radical curing agents for polymers are conversant with adjustments of cure times and temperatures required to effect optimum results with any specific free radical agent.

After molding, the core is removed from the mold and the surface thereof, preferably treated to facilitate adhesion thereof to the covering materials. Surface treatment can be effected by any of the several techniques known in the art, such as corona discharge, ozone

treatment, sand blasting, and the like.. Preferably, surface treatment is effected by grinding with an abrasive wheel.

In addition to using solid molded cores, wound cores may also be incorporated in the golf balls of the present invention. Such wound
5 covers would include a generally spherical center and a rubber thread layer, or windings, enclosing the outer surface of the center.

In this regard, the generally spherical center of the wound cores may be a solid center or a liquid center. The solid center can consist of one or more layers. For example, the solid center can comprise
10 a molded polybutadiene rubber sphere which, although smaller in size, is of similar construction to the molded cores in the two-piece molded golf balls described above.

Suitable solid centers used in the invention are not particularly limited to, but include those made of vulcanized rubber. Such
15 solid centers may be prepared by adding to butadiene rubber, additives such as vulcanizing agents, accelerators, activating agents, fillers, modifiers and aids and then subjecting the mixture to vulcanization and molding.

The solid center (whether of single unitary construction or of
20 multi-layers) generally is from 1 to 1.5 inches in diameter, preferably 1.0625 to 1.42 inches, with a weight of 15 grams to 36 grams, preferably 16.5 to 30 grams.

The wound core is formed by winding conventional thread rubber around the outer periphery of the solid center. The thread rubber
25 may include, for example, those prepared by subjecting natural rubber, or a blend of natural rubber and polyisoprene rubber to vulcanization and molding. The winding process is under high tension to produce a threaded layer over the solid or liquid center. Conventional techniques may be employed in winding the thread rubber and known compositions may be
30 used. Although the thread rubber is not limited with respect to specific

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gravity, dimension and gage, it usually has a specific gravity of .9 to 1.1, a width of .047 to .094 and a gage of .012 to .026.

The rubber thread layer has a radial thickness of .010 to .315 inches and comprises a wound core having an outer diameter of 1.52 to 1.63 inches. The overall weight of the wound core is 33 to 44 grams, preferably 35 to 39 grams.

The core is converted into a golf ball by providing at least one layer of known covering material (i.e. ionomer resins, synthetic or natural balata, polyurethane, etc.) thereon, ranging in thickness from about 0.070 to about 0.130 inches and preferably from about 0.0675 to about 0.1275 inches.

As indicated, the golf balls of the present invention may be produced by forming covers around cores by conventional molding processes. For example, in compression molding, the cover composition is formed via injection at about 380°F to about 450°F into smooth surfaced hemispherical shells which are then positioned around the core in a dimpled golf ball mold and subjected to compression molding at 200-300°F for 2-10 minutes, followed by cooling at 50-70°F for 2-10 minutes, to fuse the shells together to form an unitary ball. In addition, the golf balls may be produced by injection molding, wherein the cover composition is injected directly around the core placed in the center of a golf ball mold for a period of time at a mold temperature of from 50°F to about 100°F. After molding the golf balls produced may undergo various further processing steps such as buffing, painting, and marking.

A soft, dimpled cover layer preferably is formed from a cover material which has a flex modulus of 20 - 200 MPa, preferably 20 - 150 MPa, and more preferably 20 - 100 MPa. When a blend of hard and soft ionomers is used, the weight ratio of hard to soft ionomer is generally in the range of 3 to 97 and 80 to 20.

Golf balls according to the invention preferably have a PGA compression of 10 - 110. In a particularly preferred form of the invention,

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the golf balls have a PGA compression of about 40 - 100. It has been found that excellent results are obtained when the PGA compression of the golf balls is 60 - 100. The coefficient of restitution of the golf balls of the invention is in the range of 0.770 or greater. Preferably, the C.O.R. of
5 the golf balls is in the range of .770 - .830 and most preferably .790 - .830.

The invention has been described with reference to the preferred embodiment(s). Obviously, modifications and alterations will occur to others upon reading and understanding the preceding detailed description. It is intended that the invention be construed as including all
10 such modifications and alterations insofar as they come within the scope of the appended claims or the equivalents thereof.

For instance, it is contemplated that the processing systems B and C of the present invention can be used to process polybutadiene rubber compositions not having a high Mooney viscosity and/or a high
15 molecular weight and a low dispersity.

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